



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
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SCRAP

D3304-044

Job Sheet 212610



Part No: D3304-044

Job Qty: 1 pcs

Part Name: Tube Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/27/20

Job Tracking No:

Due Date: 9/25/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3304 REV.C IPP:D 04.11.26 Revised Steps 7 KJ/JLM IPP REV:D 19.07.23 AS PER DWG REV.C DD
VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	1			0.00	0.21	Bandsaw - 1		ALA 20/09/2020
		pcs							
110	Conventional Lathe - 1 - B4B	1			0.00	0.65	Conventional Lathe - 1 - B4B		
		pcs					Conventional Lathe - 2 - B4B		ALA 20/09/2020
120	QC 2	1			0.00	0.00	QC 2 - 1		
		pcs					QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



Container No: S302144



Part: D3304-044

Job No: 212610

Serial No/Batch: S302144

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/23/20

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CANADA
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DAS
86
9-89

			QC 2 - 63	
			QC 2 - 8	
			QC 2 - 66	
			QC 2 - 64	
			QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 2 - 83	
			QC 8 - 12	
			QC 8 - 14	20/09/23
			QC 8 - 17	
130 QC 8	1 pcs	0.00 0.00	QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
140 Small Fab - 2 - B4B	1 pcs	0.00 0.50	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	SEP 23 2020
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
150 QC 5	1 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	

			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
160 Large Fab - Welded Assy-2-B4B	1 pcs	0.00 0.56	Large Fab - 1 - B4B	
			Large Fab - 10 - B4B	
			Large Fab - 2 - B4B	
			Large Fab - 3 - B4B	
			Large Fab - 4 - B4B	
			Large Fab - 5 - B4B	
			Large Fab - 6 - B4B	
			Large Fab - 7 - B4B	
			Large Fab - 8 - B4B	
			Large Fab - 9 - B4B	
			Large Fab - 11 - B4B (Various)	
			Large Fab - 12 - B4B	
170 QC 9	1 pcs	0.00 0.00	QC 9 - 10	
			QC 9 - 18	
			QC 9 - 24	
			QC 9 - 43	
			QC 9 - 50	
			QC 9 - 9	
180 QC 5	1 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
190 Powdercoat - 3 Grey Sand - B4B	1 pcs	0.00 0.04	Powdercoat - 1 - B4B	
			Powdercoat - 2 - B4B	
			Powdercoat - 3 - B4B	
			Powdercoat - 4 - B4B	
			Powdercoat - 5 - B4B	
			Powdercoat - 6 - B4B	
			Powdercoat - 7 - B4B	

			Powdercoat - 8 - B4B	
			Powdercoat - 9 - B4B	
			Powdercoat - 10 - B4B	
200 QC 3	1 pcs	0.00 0.00	QC 3 - 10	
			QC 3 - 13	
			QC 3 - 15	
			QC 3 - 17	
			QC 3 - 18	
			QC 3 - 2	
			QC 3 - 28	
			QC 3 - 3	
			QC 3 - 30	
			QC 3 - 34	
			QC 3 - 36	
			QC 3 - 41	
			QC 3 - 51	
			QC 3 - 58	
			QC 3 - 59	
			QC 3 - 68	
			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	
			QC 3 - 82	
			QC 3 - 87	
			QC 3 - 47	
210 Small Fab - 3 - B4B	1 pcs	0.00 0.22	Small Fab - 1 - B4B	
			Small Fab - 2 - B4B	
			Small Fab - 3 - B4B	
			Small Fab - 4 - B4B	
			Small Fab - 5 - B4B	
			Small Fab - 6 - B4B	
			Small Fab - 7 - B4B	
			Small Fab - 8 - B4B	
			Small Fab - 9 - B4B	
			Small Fab - Various 1 - B4B	
220 QC 5	1 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	
			QC 5 - 40	
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	

230	Packaging 3-1 - Stock - B4B	1 pcs	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
240	QC 21 - SA	1 pcs	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 9	
				QC 21 - SA - 77	

Part Op 100 - 1- Cut blank: 22.00" as per Dwg D3304

Descriptions: 110 - 1- Cut blank: 22.00" as per Dwg D3304 2- Turn as per Dwg D3304 3- Deburr

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - QC8- Inspect parts - second check)

140 - 1- Drill as per Dwg D3304 using drill Jig D3304-T1 2- Form as per Dwg D3304 3- Cut tube to length as per Dwg D3304 4-Check with DT8657 JIG 4- Deburr

150 - (QC5- Inspect part completeness to step on W/O)

160 - Weld bracket as per Dwg D3304 and QSI 004

170 - (QC9- Inspect visual per QSI004- Fusion Welds)

180 - (QC5- Inspect part completeness to step on W/O)

190 - (Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3) START TIME: _____ OVEN TEMPERATURE: _____
FINISH TIME: _____

200 - QC3- Inspect Part Finish)

210 - Assemble lanyard and pip pin as per Dwg D3304(SEE NOTE 9) Identify as D3304-044 MANUFACTURE LANDYARD AS PER D2690-10 DWG

220 - (QC5- Inspect part completeness to step on W/O)

230 - (Identify as per dwg & Stock Location: _____)

240 - (QC21- Final Inspection - Work Order Release)

Job BOM				
Part / Item	Component Name	Quantity	Operation	Container
M304TR0.875W.065	304 Round Tube .875 X .065W	1.8542 ft (1.8542 ea)	100-Bandsaw - 1	S301428
D3304-8	Bracket	1 pcs (1 ea)	160-Large Fab - Welded Assy-2- B4B	
CBL-1240	Cable	1.0416 ft (1.0416 ea)	210-Small Fab - 3 - B4B	
CBL-460	Loop Sleeve	2 Ea (2 ea)	210-Small Fab - 3 - B4B	
NAS1353DS7S13D	Pin, Quick Release	1 Ea (1 ea)	210-Small Fab - 3 - B4B	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M304TR0.875W.065	2	0	0
160-Large Fab - Welded Assy-2- B4B	D3304-8	1	5	0
210-Small Fab - 3 - B4B	CBL-1240	1	146	0
	CBL-460	2	74	0
	NAS1353DS7S13D	1	290	0

Part Specifications
Specifications could not be found.

Plex 8/27/20 2:58 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order:	212610
Description: Tube Assembly		Part Number:	D3304-3
Inspection Dwg: D3304	Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article** ☐ **Prototype**

[illegible]

Measured by: ALA	Audited by: 	Prototype Approval: N/A
Date: 20/09/23	Date: 20/09/23	Date: N/A

Rev	Date	Change	Revised by	Approved
A	04.09.08	New Issue P/O D3304-043/-044	KJ/JLM	
B	06.03.09	Dwg Rev updated	KJ/JLM	

Entered: 2R Date: OCT 21 2020



NCR No. 20-8608 **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only ☐

Job: <u>212610</u>	DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐	DEPARTMENT/PROCESS			
Part No. <u>23304-044</u>		Skid-tube ☐ Machining ☐ Large Fab ☐	Cross tube ☐ Small Fab ☒ Finishing ☐	Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐

Date: 23/09/2020 Sequence #: 140 QTY Affected: 1 MRB (QS1042)

Description Work Order Deviation	Disposition	
Bad bend which cause crushing inside the top bend.	Scrap & destroy	PD 20-09-24 Completed By SEP 23 2020 Lead hand / Supervisor DAS 58 SEP 23 2020 9-89 QC / QA Coordinator PD 20-9-24

Root Cause Operator ☒ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐	FAULT CATEGORY <table> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☒ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☐ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>	☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☒ Bending	☐ Misaligned/off center	☐ Folio/Program	☐ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
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Other/Details:																													